

Date: Thursday, 6/7/2007 3:34:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHIM
Job Number	: 32875		
Estimate Number	: 10915		
P.O. Number	: N/A	Part Number	: D34421
This Issue	: 6/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3442 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30564	Drawing Revision	: A
		Material	: N/A
		Due Date	: 6/15/2007
Written By	:	Qty:	20
Checked & Approved By	:	Um:	Each
Comment	: Est. A 05.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.0420 sf(s)/Unit Total : 0.8400 sf(s)
 304/316 .032 Sheet
 Batch: M102159

SAP 07/06/14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3442
 Dwg Rev: A
 Prog Rev: A

SAP 07/06/14

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/06/14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/14

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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



Comment: Deburr if necessary.

SAP 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/07/17	2.0	lost one part in water jet tank, tab was not big enough		Scrap, destroy, replace made tab bigger	SAD 07/06/18  07/06/18	En 07/06/18		En 07/06/18

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:34:25 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 32875

Part Number: D34421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/EN 07/04/20 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57102*

6 7/6/21 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6 7/04/20 (20)

Job Completion



6 07-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

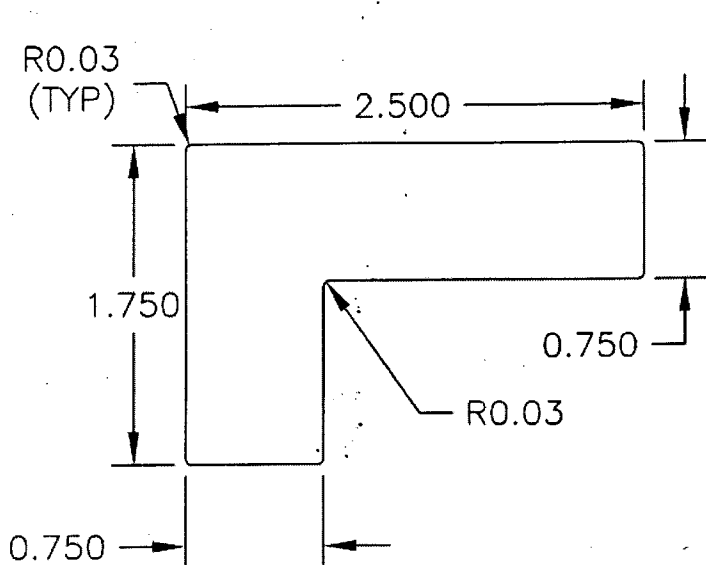
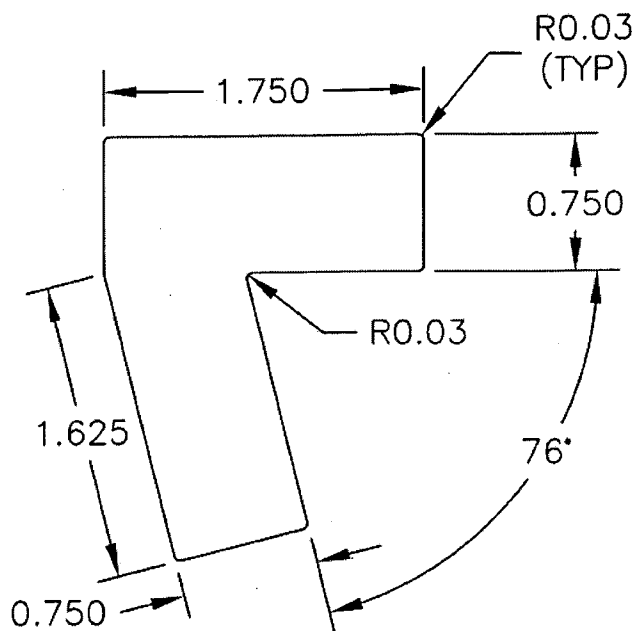
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

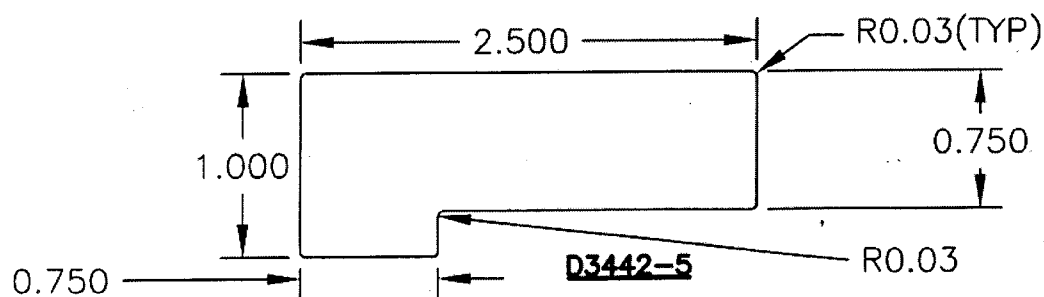
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	

**D3442-1****D3442-3****D3442-1/-3 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3442-5****D3442-5 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32875

RELEASED

05.08.19 #

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DART AEROSPACE LTD		Work Order: 32875
Description: Shim		Part Number: D3442-1
Inspection Dwg: 328	Rev: A	Page 1 of 1

D3442-1 FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.750	+/-0.010	1.749	✓		Vern	
B 2.500	+/-0.010	2.504	✓		Vern	
C 0.750	+/-0.010	0.752	✓		Vern	
D 0.034	+/-0.010	0.034	✓		Vern	
E 0.750	+/-0.010	0.752	✓		Vern	
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: JAD	Audited by: En	Prototype Approval:	N/A
Date: 07/06/14	Date: 07/06/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

[Handwritten signature]